

Work Order ID 60558

Wednesday, July 14, 2010 9:17:05 AM



Page 1

Item ID: D3565-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: 1/

Date: 10-7-14

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3565

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

364 .063

B 10-7-21

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-7-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S.OLAH22

FS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Large Fab

Large Fab

Memo

0.00

0.00

1-Weld D3009-3 cups as per dwg D3565 2-Weld hard facing as per Dwg
D3565 using DT8991 jig A/R 2059B Hard Coat rod
Batch: M114705

EL 10-7-28 (XB)

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

Cpl 10.07.28

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/6/28

(XB)

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NOTE: Date & initial all entries

[illegible]

Page 3

Accept

[illegible]**Setup Start**[illegible]

Stop

Abstract

Start

Abstract

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

[illegible]

Date: _____

Stop

4

Date:

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

M12588

0.00

Powdercoat

Memo

Powder Coating

START TIME:

11:00

□OVEN TEMPERATURE:

320 ☐ FINISH TIME:

1130.

0.00



Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location: 997A

0.00

[illegible]

Memo

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES						
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Page 4

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Accept

Revision ID:

Item Name: Wearplate

Start Date: 7/14/2010 Start Qty: 4.00

Required Date: 7/22/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1060810978

MF
10-8-6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, July 14, 2010 9:17:09 AM

Page 1

Work Order ID: 60558

Parent Item: D3565-1

Parent Item Name: Wearplate



Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-16 JLM
 IPP rev B revB dwg 07.04.18 ec
 IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
 IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3  Cup		Manufactured	No			100	Each	329.0000	3	12			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				329					
					42377			329					
M304S16GA  304/316 Sheet .063		Purchased	No			130	sf	51.5039	0.135	0.568421			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT				51.50389474					
					111323			0					
					114799			51.5038947					

10-7-27

24

1.1

10-7-21

8

114799

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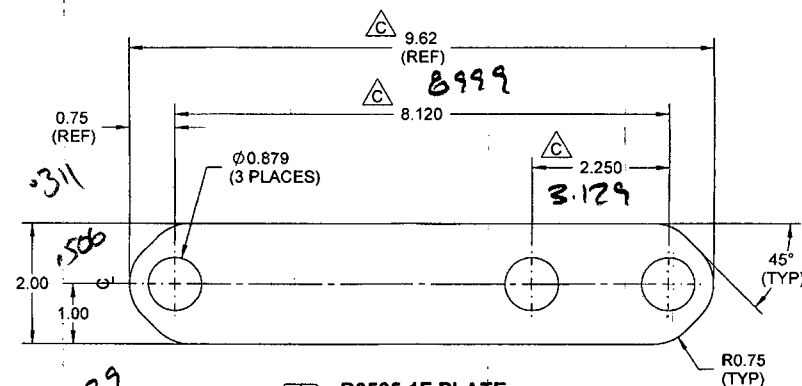
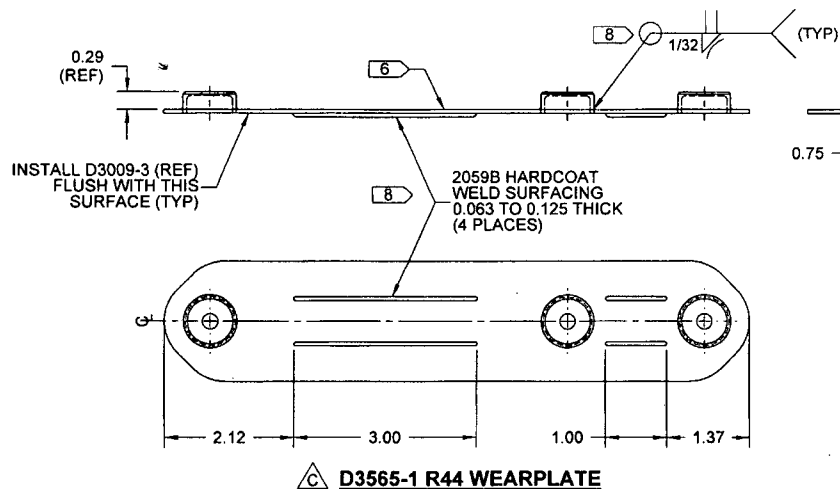
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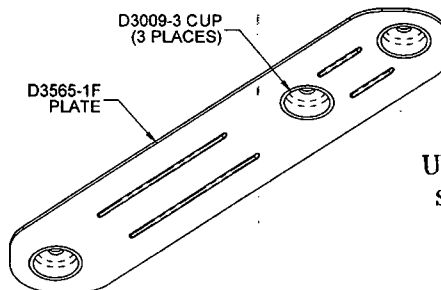


D3565-1 PARTS LIST

QTY	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT C



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60558

RELEASED
06-01-11

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300, (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3565
TITLE R44 WEARPLATE
REV. C
SHEET 1 OF 1
SCALE 1:2

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